



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

ASAD
Vegut

D3502-1
Job Sheet 184902



Part No: D3502-1

Job Qty: 40 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/17/18

Job Tracking No:

Due Date: 11/9/18 *Sumid*

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP Rev:A New Issue 06-07-06 JLM IPP Rev:B Add tooling hole 07-03-28 Esr rev C added
DT9430 08.11.03 EC verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	40 pcs	11/9/18	11/9/18	0.00	1.57	Bandsaw - 1		<i>VH8 19/6/6</i>
110	HAAS 4 Axis - B4B	40 pcs	11/9/18	11/9/18	0.16	13.38	HAAS - 1 - B4B		<i>VH8 19/6/6</i>
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	40 pcs	11/9/18	11/9/18	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		<i>SF 19-06-07</i>
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
140	Small Fab - 2 - B4B	40	11/9/18	11/9/18	0.00	1.24	Small Fab - 1 - B4B		



Container No: S188464



Part: D3502-1

Job No: 184902

Serial No/Batch: S188464

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/06/19

	pcs				Small Fab - 2 - B4B		DAS
					Small Fab - 3 - B4B		71
					Small Fab - 4 - B4B		9-89
					Small Fab - 5 - B4B	19-6-18	
					Small Fab - 6 - B4B		
					Small Fab - 7 - B4B		
150 Handfinish - 1-1 Chemical-B4B	40 pcs	11/9/18	0.00 0.68		Handfinish - 1 - 1 - B4B		
					Handfinish - 1 - 2 - B4B		
					Handfinish - 1 - 3 - B4B		JUN 19 2019
					Handfinish - 1 - 4 - B4B		
					Handfinish - 1 - 5 - B4B		
					Handfinish - 1 - 6 - B4B		
					Handfinish - 1 - 7 - B4B		
					Handfinish - 1 - 8 - B4B		
					Handfinish - 1 - 9 - B4B		
					Handfinish - 1 - 10 - B4B		
					Handfinish - 1 - 11 - B4B		
					Handfinish - 1 - 12 - B4B		
					Handfinish - 1 - 13 - B4B		
					Handfinish - 1 - 14 - B4B		
					Handfinish - 1 - 15 - B4B		
					Handfinish - 1 - 16 - B4B		
					Handfinish - 1 - 17 - B4B		
					Handfinish - 1 - 18 - B4B		
					Handfinish - 1 - 19 - B4B		
					Handfinish - 1 - 20 - B4B		
					Handfinish - 1 - 21 - B4B		
					Handfinish - 1 - 22 - B4B		
160 Powdercoat - 1 White Gl(A)-B4B	40 pcs	11/9/18	0.00 0.63		Powdercoat - 1 - B4B		
					Powdercoat - 2 - B4B		
					Powdercoat - 3 - B4B		
					Powdercoat - 4 - B4B		
170 QC 3	40 pcs	11/9/18	0.00 0.00		QC 3 - 10		
					QC 3 - 13		
					QC 3 - 15		
					QC 3 - 17		
					QC 3 - 18		
					QC 3 - 2		
					QC 3 - 28		
					QC 3 - 3		
					QC 3 - 30		

				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	DAS
				QC 3 - 40	JUN 20 2019 40
				QC 3 - 19	9-89
180	Packaging 3-1 - Stock - B4B	40	11/9/18	0.00 0.00	Packaging 3 - 1 - B4B
		pcs			Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B

					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190 QC 21 - SA	40 pcs	11/9/18	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	345
					QC 21 - SA - 53	21 JUN 21 2019

Part Op 100 - Cut blank 3.475 " long 1 BLANK MAKES 2 PARTS
 Descriptions: 110 - 1- Mill as per Folio FA649 Rev: _____ & Dwg D3502 Rev: _____ 2-Deburr per dwg D3502
 130 - (QC8- Inspect parts - second chec
 140 - Mark hole position using DT9430 Drill as per Dwg D3502.
 150 - (Chemical Conversion Coat per QSI005 4.1)
 160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____
 170 - (QC3- Inspect Part Finish)
 180 - Identify as per dwg & Stock LOCATION : LG052
 190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X04.000	6061-T6 Bar 1.00 X 4.00	5.7800 ft (.1445 ea)	100-Bandsaw - 1	5150 595 x 11.75 5.875

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.000X04.000	6	66	0

Part Specifications

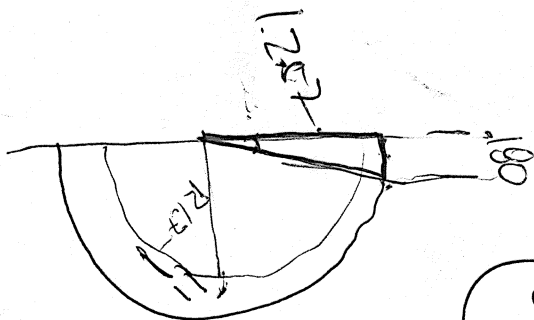
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Support	1.590inches ± 0.010	1.600 1.580		1,595
2	Support	1.177inches + 0.005 - 0.000	1.182 1.177		1,177
3	Support	0.130inches ± 0.010	0.140 0.120		1,120
4	Support	0.080inches ± 0.010	0.090 0.070		1,080
5	Support	0.928inches ± 0.010	0.938 0.918		1,931
6	Support	0.100inches ± 0.010	0.110 0.090		0,107
7	Support	0.100inches ± 0.010	0.110 0.090		0,097
8	Support	1.390inches ± 0.030	1.420 1.360		1,395

Plex 6/3/19 7:29 AM dart.lacelle.linda

11.75' used
 5.78' Bom
 Scrap = 5.97'

Q.2.

SOH CWD to A

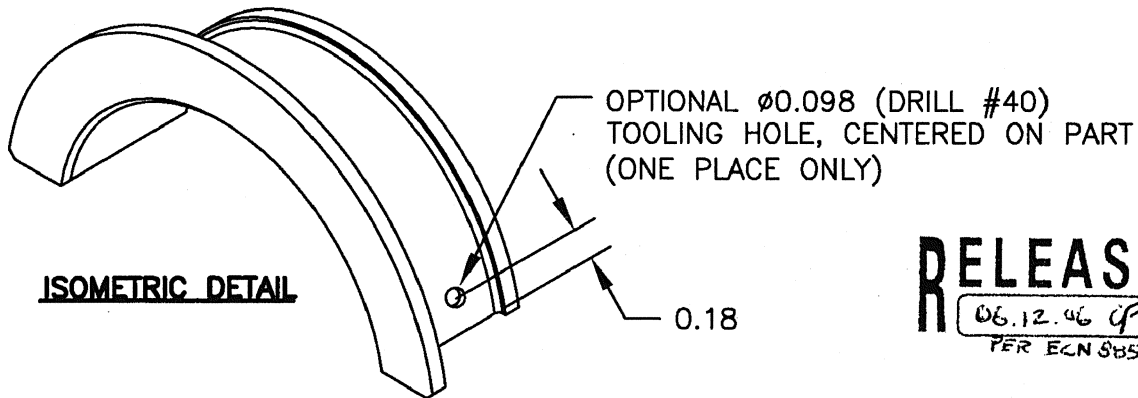


$$+ L = \frac{.180}{1.257}$$

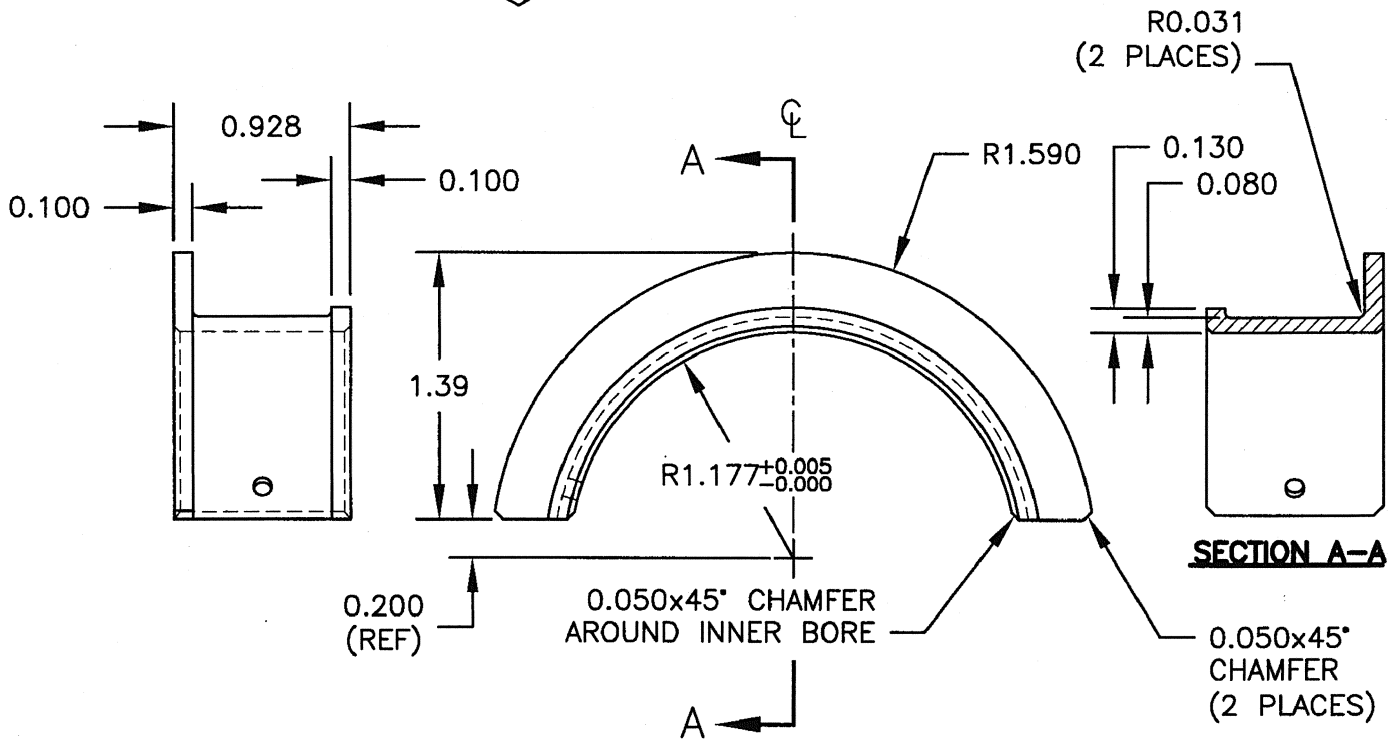
$$\frac{1.177}{.080} \div 1.257$$

DART

DESIGN qp	DRAWN BY qp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3502	REV. B SHEET 1 OF 1
DATE 06.10.31	TITLE SUPPORT		SCALE 1:1
A	06.04.18	NEW ISSUE	
B	06.10.31	ADD TOOLING HOLE FOR FINISHING	



RELEASED
06.12.46 qp
PER ECN 885



D3502-1 SUPPORT

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010 , X.XX = ± 0.030) UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

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